

Split

Work Order ID 61683 - 2



Page 1

Tuesday, August 31, 2010 11:48:16 AM

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 8/31/2010 Start Qty: 4.00

Required Date: 9/7/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan:

Date: 10-8-31 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2360

Rev D

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 12.65" Long

0.00

0.00

SL 10/11/22



110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio D2341 and Dwg D2341
2-Deburr

0.00

0.00

SL 10/12/22



120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SL 10/12/22

6

Work Order ID 61683

Tuesday, August 31, 2010 11:48:16 AM



Page 2

Item ID: D2360

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Tie Down Assembly

Start Date: 8/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



2nd 10/12/22

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



6 BR 10-12-22.

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



MUS951.

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:05
320°
8:35

6 BR 10-12-23.

Work Order ID 61683

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Item ID: D2360

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Tie Down Assembly

Start Date: 8/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

⇒ 11

10/12/23

6

0

Memo

0.00

170



Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D2360

0.00

0.00

8/31/02/22 (3)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/22

0.00

(13)

Memo

Work Order ID 61683

Tuesday, August 31, 2010 11:48:16 AM



Item ID: D2360

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Tie Down Assembly

Start Date: 8/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Packaging

Identify as per dwg & Stock Location

22y

0.00

Memo

0.00

Packaging

11/02/23 (3)

200



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/02/23 (3)

11-02-23 (3)

Picklist Print

Tuesday, August 31, 2010 11:48:21 AM

Page 1

Work Order ID: 61683



Parent Item: D2360



Parent Item Name: Litter Tie Down Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6201

Manufactured

No

100

f

22.3468

1.054

4.437895



22 10/11/22

"T" Extrusion

Location

Loc Qty

Loc Code

MAT05

22.34684

56424

6.61

57767

15.73684

AN526C1032R18

Purchased

No

170

Each

589.0000

1

4



EP 5/11/01/06

Screw

Location

Loc Qty

Loc Code

ST328

589

101458

65

108079

419

4523

105

6

AN960JD10

NAS1149D0363J Purchased

No

170

Each

6.0000

2

8



Washer

LD M115622

(12K)



EP 5/11/01/06

Location

Loc Qty

Loc Code

ST

6

107715

6

170

Each

2,479.000

8

32

AN960JD10L

NAS1149D0332J Purchased

No



Washer

LD M116441

(4K)



EP 5/11/01/06

Location

Loc Qty

Loc Code

ST348

2479

110985

2479

Picklist Print

Page 2

Tuesday, August 31, 2010 11:48:21 AM

Work Order ID: 61683

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 4.00

Required Qty: 4.00

D2002-015

Manufactured No

170

Each

47.0000

2

8



Knob

Location

Loc Qty

Loc Code

ST003

47

16177

47

170

Each

9.0000

1

4

D2345

Manufactured No



Lock Channel

Location

Loc Qty

Loc Code

ST011

9

57762

9

170

Each

6.0000

2

8

D2366

Manufactured No



Lock Handle

Location

Loc Qty

Loc Code

ST012

6

57763

6

170

Each

7.0000

1

4

D2367

Manufactured No



Handle Knob

Location

Loc Qty

Loc Code

ST012

7

57764

7

170

Each

29.0000

2

8

* D2372



Quick Release

Location

Loc Qty

Loc Code

ST012

29

57765

2

60716

27

EP 8/31/06

12

EP 8/31/06

6

EP 8/31/06

B66512

8

EP 8/31/06

6

EP 8/31/06

8

B60716

B64755

Tuesday, August 31, 2010 11:48:21 AM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 61683

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 4.00

Required Qty: 4.00

D2373

Manufactured No

170

Each

7.0000

1



Spring



4
E511/01/06

Location

Loc Qty

Loc Code

ST012

7

42920

7

170

Each

6.0000

1

Manufactured No

D2444



Pip Pin Assembly



6
4
E511/01/06 E511/02/22
B64754 (X) (X)

Location

Loc Qty

Loc Code

ST014

6

57766

3

60154

1

61342

2

170

Each

10,620.00

1

Purchased

No

MS20470AD3-4



Rivet, Universal Head



B65326 (2x)
B64089 (2x)
4
E511/01/06

Location

Loc Qty

Loc Code

ST319

10620

111477

8332

15541

2288

170

Each

2,115.000

3

Purchased

No

MS21042L3



Nut



6
12
E511/01/06
M115835 (18x)

Location

Loc Qty

Loc Code

ST300

2115

114523

115

114784

2000

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Shop Packet Print

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Picklist Print

Tuesday, August 31, 2010 11:48:21 AM

Page 4

Work Order ID: 61683

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-13

Purchased

No

170

Each

58.0000

1

4



Screw



Ep 11/01/06

Location

Loc Qty

Loc Code

ST292

58

110844

58

170

Each

85.0000

2

8

MS27039-1-15

Purchased

No



Screw



Ep 11/01/06

Location

Loc Qty

Loc Code

ST292

85

114056

2

114718

83

170

Each

225.0000

1

4

NAS679A3W

Purchased

No



Nut



Ep 11/01/06

Location

Loc Qty

Loc Code

ST280

225

1463

32

2409

193

6

M116168 (12x)

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Shop Packet Print

Page 4

DART AEROSPACE LTD		Work Order: 61683
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.750	✓		vern. 1-3	
2.75	+/-0.030	2.753	✓			
Ø0.242	+0.005/-0.001	0.244	✓			
Ø0.191	+0.005/-0.001	0.193	✓			
R0.25	+/-0.030	0.25	✓		B-G	
R0.40	+/-0.030	0.40	✓		P	
12.50	+/-0.030	12.505	✓		H-G	
11.750	+/-0.010	11.752	✓		vern. CNC-02	
11.00	+/-0.030	11.001	✓		H-G	
7.00	+/-0.030	7.003	✓		H-G	
6.250	+/-0.010	6.251	✓		vern. CNC-02	
5.50	+/-0.030	5.497	✓		H-G	
1.50	+/-0.030	1.503	✓		vern. 1-3	
0.750	+/-0.010	0.751	✓			
0.400	+/-0.010	0.400	✓			
1.584	+/-0.010	1.586	✓			
2.610	+/-0.010	2.611	✓			
0.250	+/-0.010	0.251	✓			
0.844	+/-0.010	0.843	✓			
Ø0.250	+/-0.010	0.250	✓			
0.750	+/-0.010	0.750	✓			
3.313	+/-0.010	3.314	✓			
4.250	+/-0.010	4.250	✓			
1.250	+/-0.010	1.252	✓			

Measured by: SL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10/12/22	Date: 10/12/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	[Signature]

DART**RELEASED**

07 de 01

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

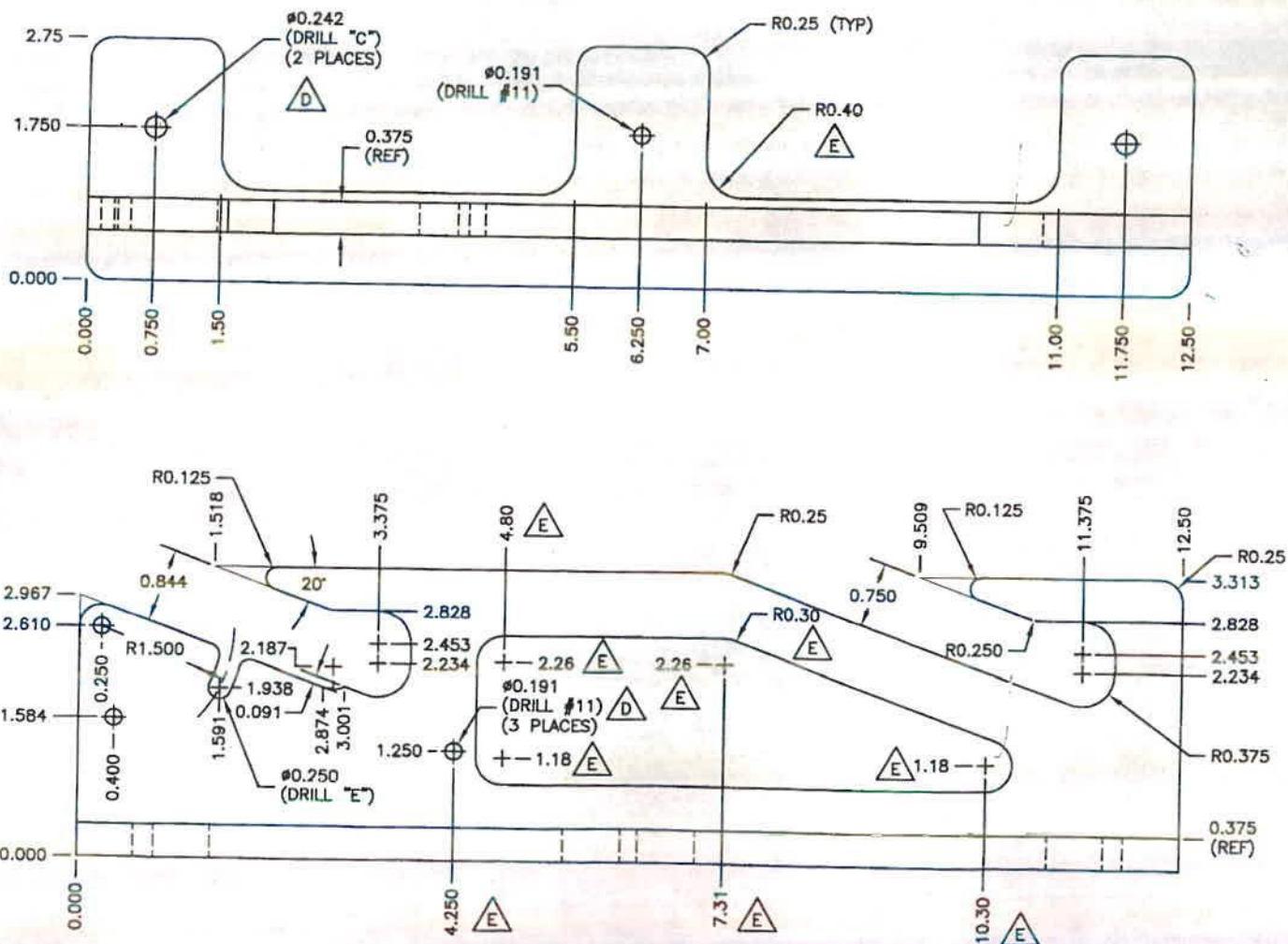
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DART

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
(6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER

RELEASED

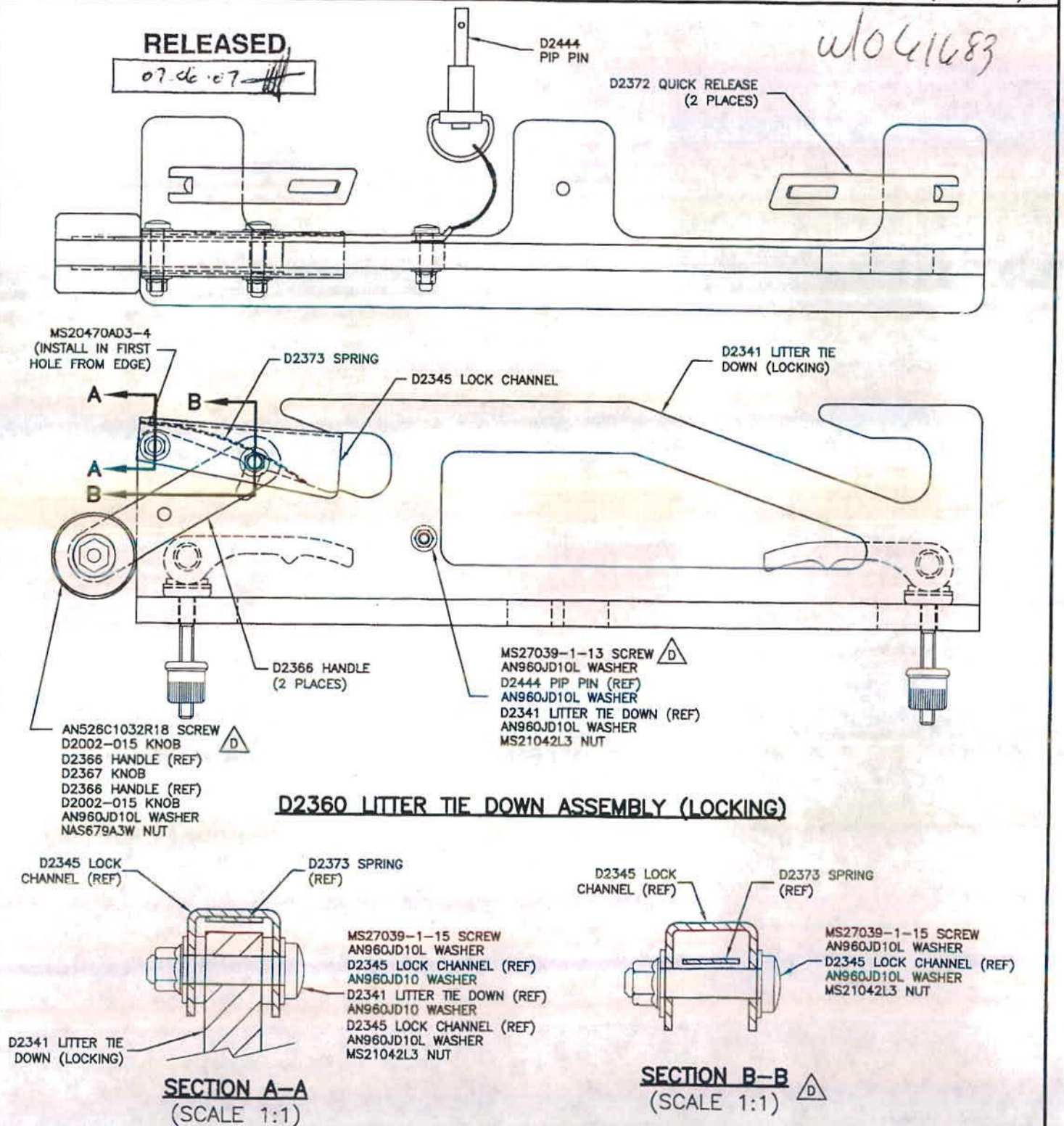
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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS		



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